

# Work Order ID 86968

**\*86968\***

Page 1

July-10-12 9:09:51 AM

Item ID: D3204-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Tube  
 Start Date: 7/10/12 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: ML5 Date: 12/07/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3204	Rev A1								

100 Hardinge CNC LATHE SMALL 0.00  
**\*100\*** OK 12/07/14 4 0  
 Hardinge Memo  
 Hardinge CNC Lathe Small 1-Turn tube as per Folio FA356 and Dwg D32042-Deburr

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\*** OK 12/07/14 4 0  
 QC Memo  
 Quality Control

120 QC8- Inspect parts - second check 0.00  
**\*120\*** OK 12-7-12 4 0  
 QC Memo  
 Quality Control

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*86968\***

July-10-12 9:09:51 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Start Date:** 7/10/12      **Start Qty:** 4.00      **\*4\***

**Cust Item ID:**

**Required Date:** 8/10/12      **Req'd Qty:** 4.00      **\*4\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

130

**\*130\***

### Packaging

## Packaging

Identify as per dwg & Stock Location: W/A

### Set Up/ Run Hours

0.00

0.00

**Tool ID****Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
Qty

### Reject Number

**Insp.  
Stamp**

4

Q 12-7-17

## Memo

\*\*\*\*\*STOCK IN LARGE FAB\*\*\*\*\*

0.00

0.00

140


\*140\*

QC

## Quality Control

QC21- Final Inspection - Work Order Release

## Memo

12/7/18 

mf  
12-07-17

# Dart Aerospace Ltd

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# Picklist Print

July-10-12 9:09:50 AM

Page 1

Work Order ID: 86968

Parent Item: D3204-1

Parent Item Name: Tube

Start Date: 7/10/12

Required Date: 8/10/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B04.06.09Change Step 6; remove Steps 7 & 8KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.750W.125 6061-T6 RD Tube .750 x .125W		Purchased	No			100	f	50.7000	0.52	2.1894736			

Location

Loc Qty

Loc Code

MAT015

50.7

→ 117635

2.7

120918

48

2.7

OK 12/07/16

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**Dart Aerospace Ltd**

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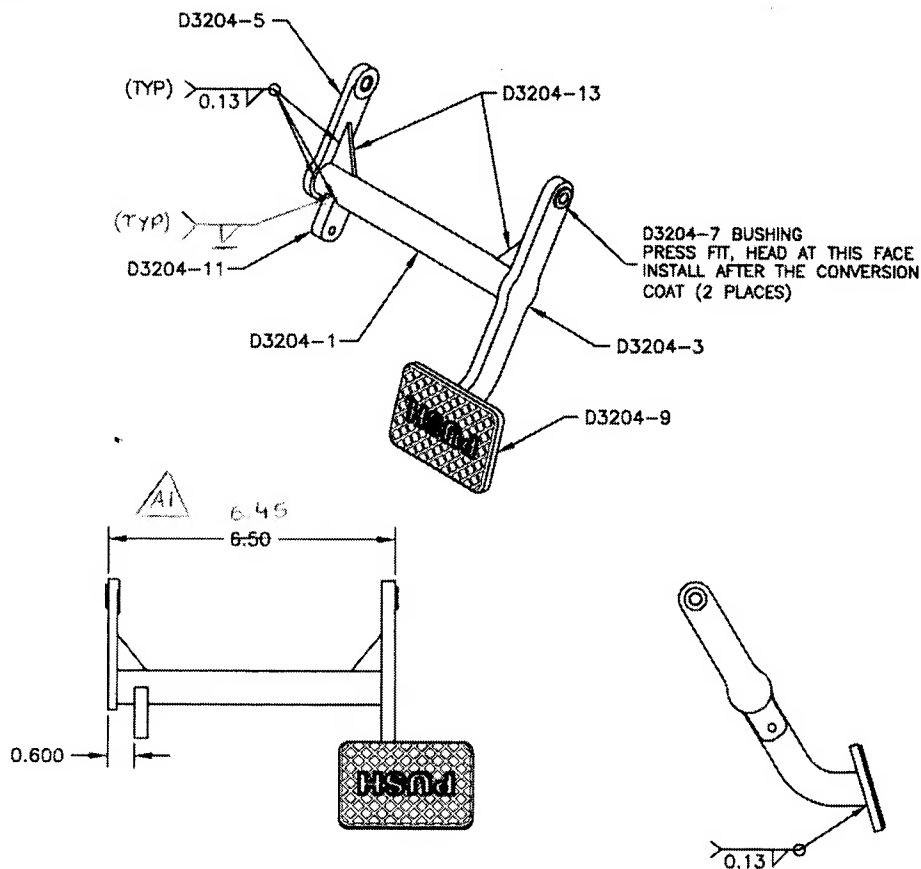
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CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED  
04.04.30



**D3204-041 RELEASE PEDAL ASSEMBLY**

**NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26968MWS  
12/07/10

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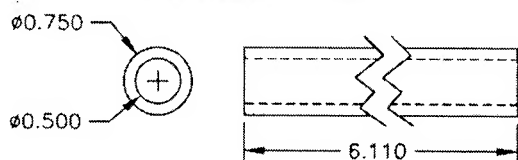
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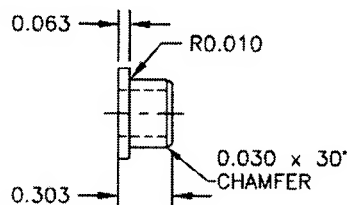


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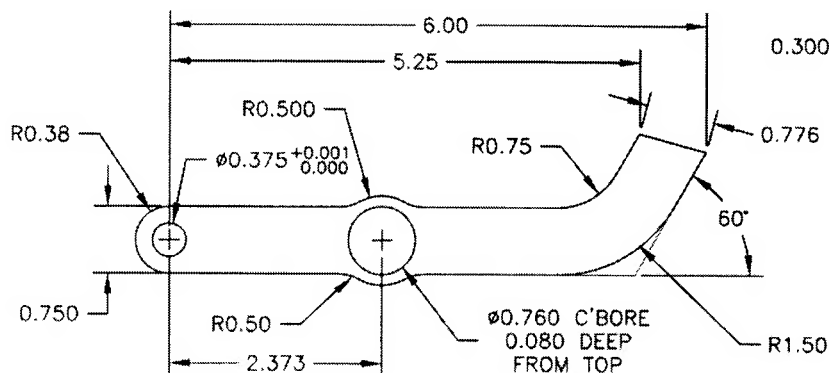
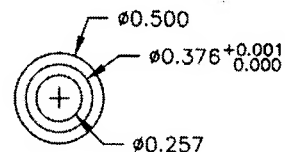
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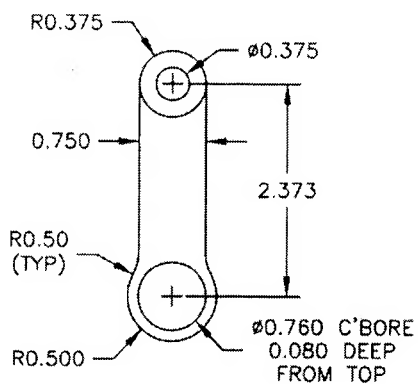
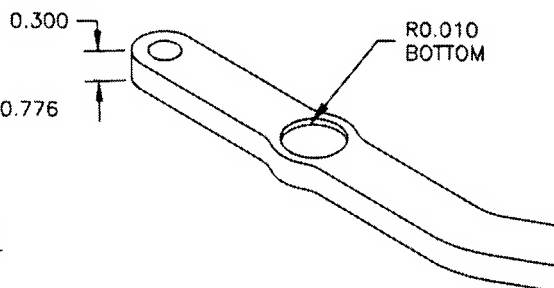
2 D3204-1 TUBE  
SCALE 1:2



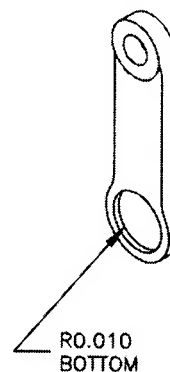
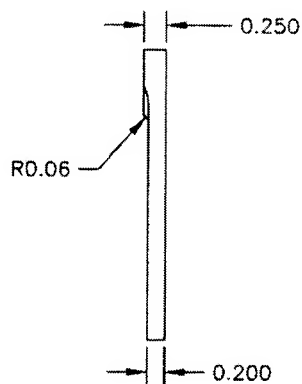
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



26962

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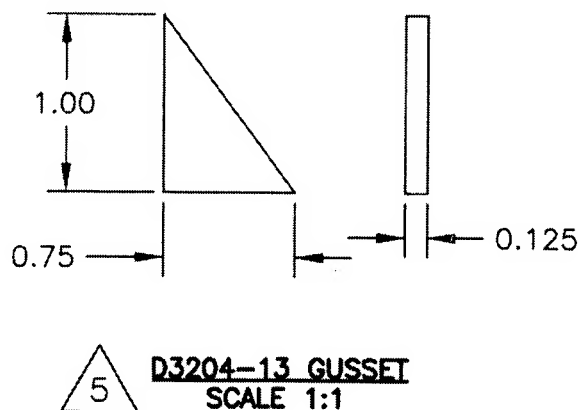
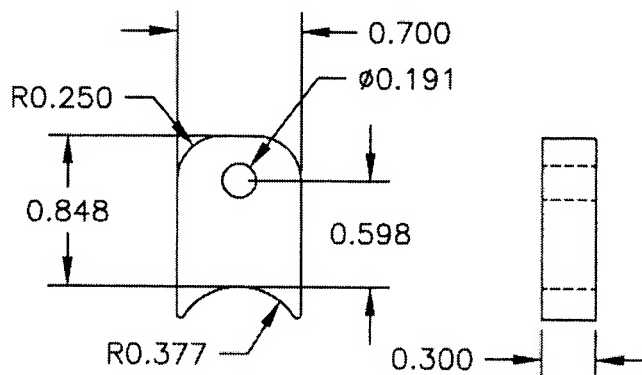
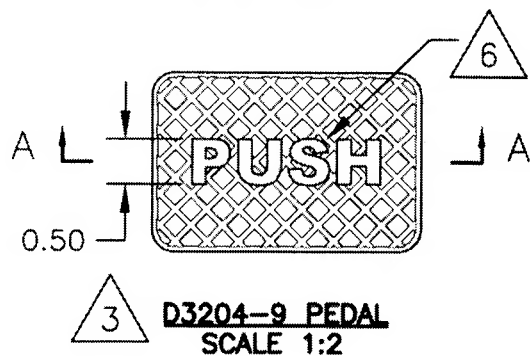
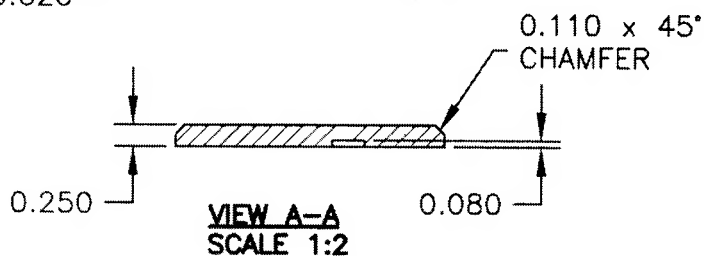
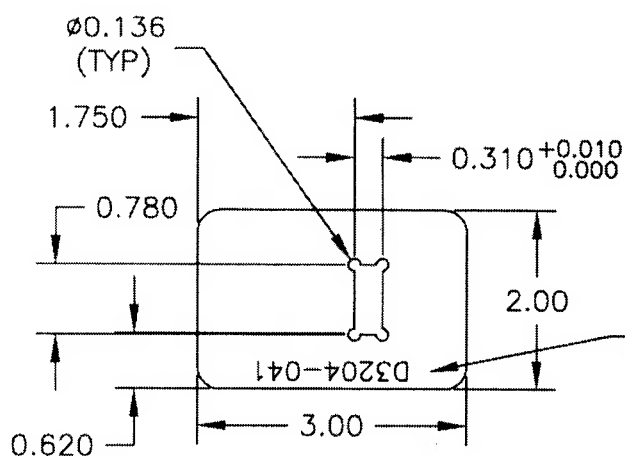
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